

Work Order ID 72203

Wednesday, July 20, 2011 7:50:53 AM



Page 1

Item ID: D3508-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 7/19/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 7-07-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3508

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3508 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Debur if necessary

304 .040

B11-8-9

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-8-9

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Dulosky

412

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72203

Wednesday, July 20, 2011 7:50:53 AM



Page 2

Item ID: D3508-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 7/19/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Deburr and form on brake using DT8326 and DT8261 as per Dwg D3508

12 110812

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

S wacker



150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:45

8:15

3200F

12x 11/08/15

M 117338

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72203

Wednesday, July 20, 2011 7:50:53 AM



Page 3

Item ID: D3508-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 7/19/2011 Start Qty: 8.00

Required Date: 7/26/2011 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

12 ϕ 11/10/15

170



Packaging

Packaging

Identify as per dwg & Stock Location:

F-P1

0.00

Memo

0.00

12x ϕ m/11/08/15

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/8/15

MF
11-08-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 20, 2011 7:51:01 AM

Page 1

Work Order ID: 72203



Parent Item: D3508-9



Parent Item Name: Wearplate


Start Date: 7/19/2011

Required Date: 7/26/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07.06.12 EC
IPP Rev:B Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	110.0630	0.417	3.511579	5, 13 11-8-9		

Location

Loc Qty

Loc Code

MAT020

110.063

116623

0.2

117550

9.363

117933

100.5

118400

118400

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	72203
Description: Wearplate		Part Number:	D3508-9
Inspection Dwg: D3508 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.068	✓		V 1B02	
2.813	+/-0.010	2.814	✓		V	
0.375	+/-0.010	.374	✓		V	
2.90	+/-0.030	2.90	✓		V	
5.800	+/-0.010	5.800	✓		T 1B01	
11.600	+/-0.010	11.600	✓		T	
17.400	+/-0.010	17.400	✓		T	
Ø0.188	+0.005/-0.001	.192	✓		V	
0.300	+/-0.010	.306	✓		V	
0.300	+/-0.010	.304	✓		V	
0.038	+/-0.010	.035	✗		V	

Measured by: RB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11-9-8	Date: 11/08/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD [Signature]	[Signature]

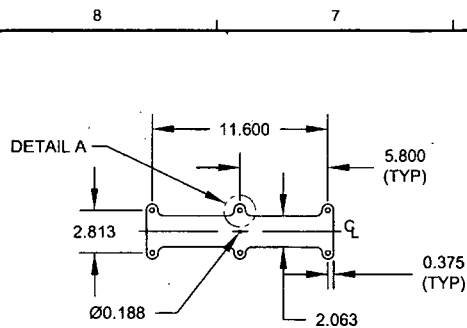
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

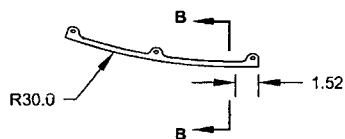
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

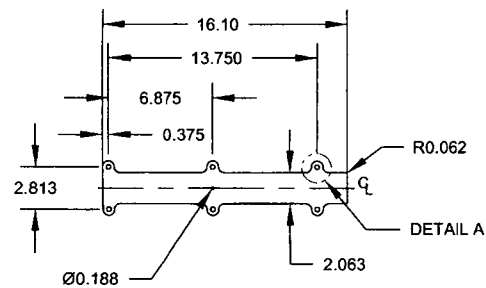
NOTE: Date & initial all entries



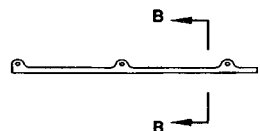
D3508-1 FLAT PATTERN



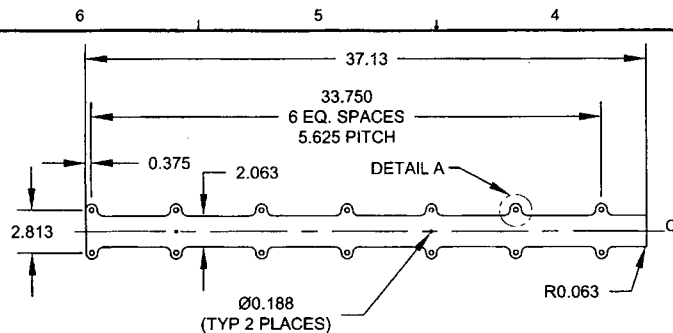
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



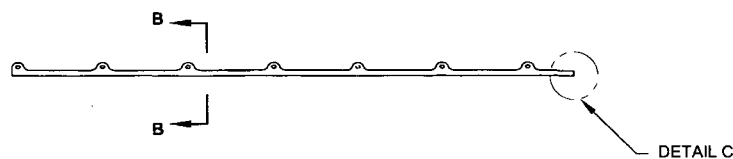
D3508-7F FLAT PATTERN



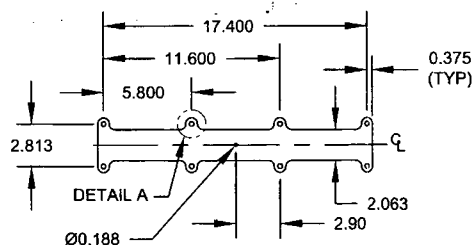
D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



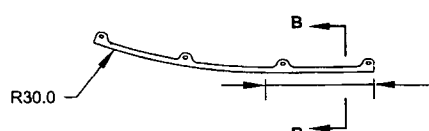
D3508-3 FLAT PATTERN



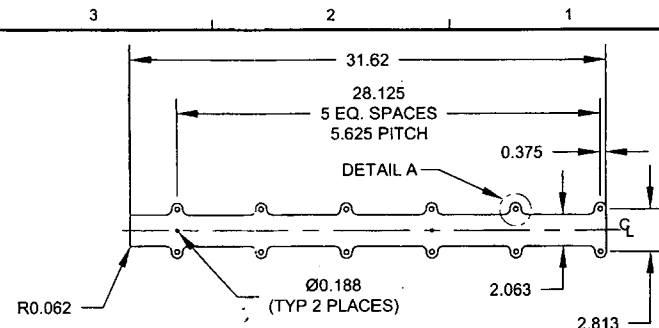
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



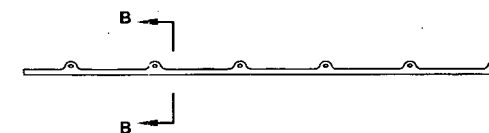
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07-11-16

C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.04.20		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3508
TITLE WEARPLATE
SCALE 1:8

REV. C
SHEET 1 OF 2

COPYRIGHT © 2007 BY DART AEROSPACE USA, INC
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72203

PL 11-07-20

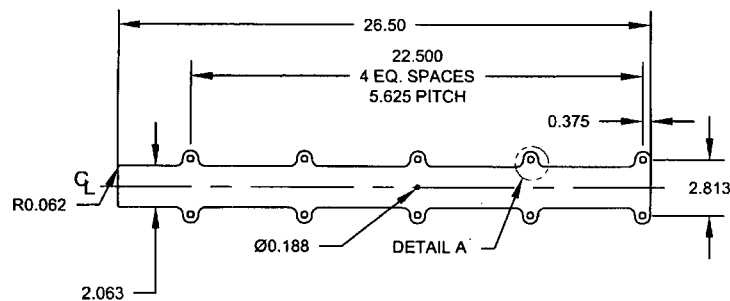
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

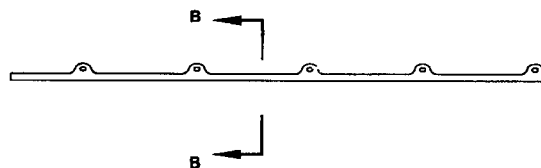
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

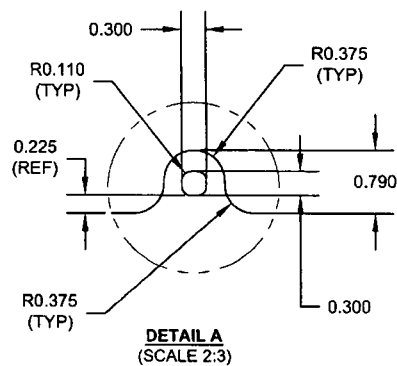
NOTE: Date & initial all entries



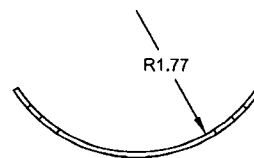
D3508-11F FLAT PATTERN



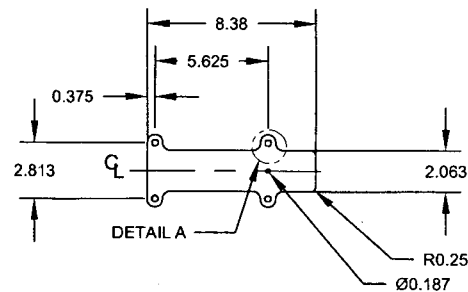
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



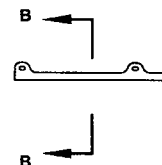
DETAIL A
(SCALE 2:3)



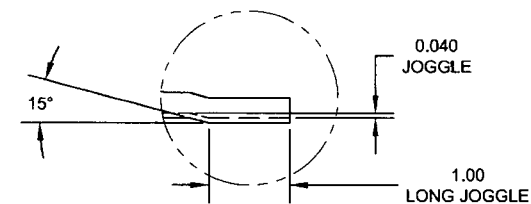
SECTION B-B
(SCALE 2:3)



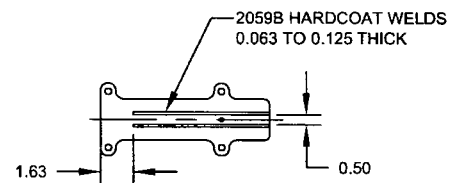
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

RELEASED
07-11-16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3508	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:6
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries